

**Work Order ID 64393**

Friday, December 03, 2010 1:47:53 PM



Page 1

Item ID: D044-713-014

Accept



Setup

Start



Revision ID:

Item Name: Bubble Window, RH

Stop



Start Date: 12/3/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/12/3

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	100	DOCUMENT CONTROL	0.00	0.00	0.00	0.00
N/A	I1044-713 Rev N/A Rev A								
100									
DC									
Document Control									
		Photocopy bluefiles and create labels per PPP D044-713-014 & DSI 9329 CHG002							
		CHG003 (Windows are untrivex).	5	10/12/01					
110	Pick Kit		0.00						
Packaging									
Packaging		Memo	0.00						
120	QC4- 100% Inspect kits for completeness		0.00						
QC									
Quality Control		Memo	0.00						

(3)

(3)

W/O: 64393

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE Perm. change.	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/21	# 100	update (or at least add information) to header box IN DO44-713 Rev A.	G	10.12.22		S	10/12/21
10/12/21	# 100	update chg # to 003.	G	10.12.22		S	10/12/21

Part No: DO44-713-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Work Order ID 64393**

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Item ID: D044-713-014

Accept



Setup Start



Revision ID:

Item Name: Bubble Window, RH

Stop



Start Date: 12/3/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
Description

Packaging

Memo

Identify and pack for shipping as per PPP D044-713-014  
Location: 91  
PPP Rev: CSet Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

CD/12/22 SP 30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/22 JJ

CD/10/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 64393



Parent Item: D044-713-014



Parent Item Name: Bubble Window, RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 05.03.22 New issue KJ/JLM  
IPP Rev:A 06-07-03 As per DSI 9329 JLM  
IPP Rev:C 08-07-30 chg qty DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8720 		Manufactured	No			110	Each	0.0000	1	59			
template 		Manufactured	No			110	f	115.1819	7.525	23.76316		10/12/2010	
D2126 		Manufactured	No										
Seal 		(D2126 - 0903) cut to 90.3"	measured 5/12/10										
D3269-2 		Manufactured	No			ST405	Loc	Qty	Loc	Code			
Bubble Window, RH						48285		115.1819211					
D3312-1 		Manufactured	No			57106		22.0884211					
Placard 		Manufactured	No				110	Each	6.0000	1	3	64394	C
						ST051	Loc	Qty	Loc	Code			
						28101		6					
								6			3		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

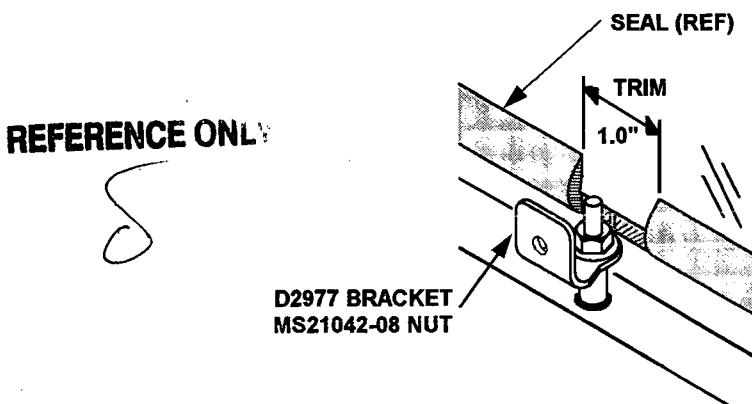


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

#### 4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	$\pm 24$ in $\pm 0.61$ m	$\pm 36$ in-lb $\pm 0.43$ m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	$\pm 23$ in $\pm 0.58$ m	$\pm 28$ in-lb $\pm 0.31$ m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

#### 5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
				1	SEAL
1	1	*1		D2126-0720	SEAL
				D2126-0903	SEAL
1				D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
1	1			D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

\* Not to be installed. Cutting template only.

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Revision: A  
Date: 05.01.10

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9329	REV. B SHEET 1 OF 1
DATE 06.06.26		TITLE BUBBLE WINDOW INSTALL MOD.	SCALE NTS
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

**REFERENCE ONLY**

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A

REF. CANADIAN STC: SH05-13 ISSUE 1

REF. FAA STC: SR02088NY

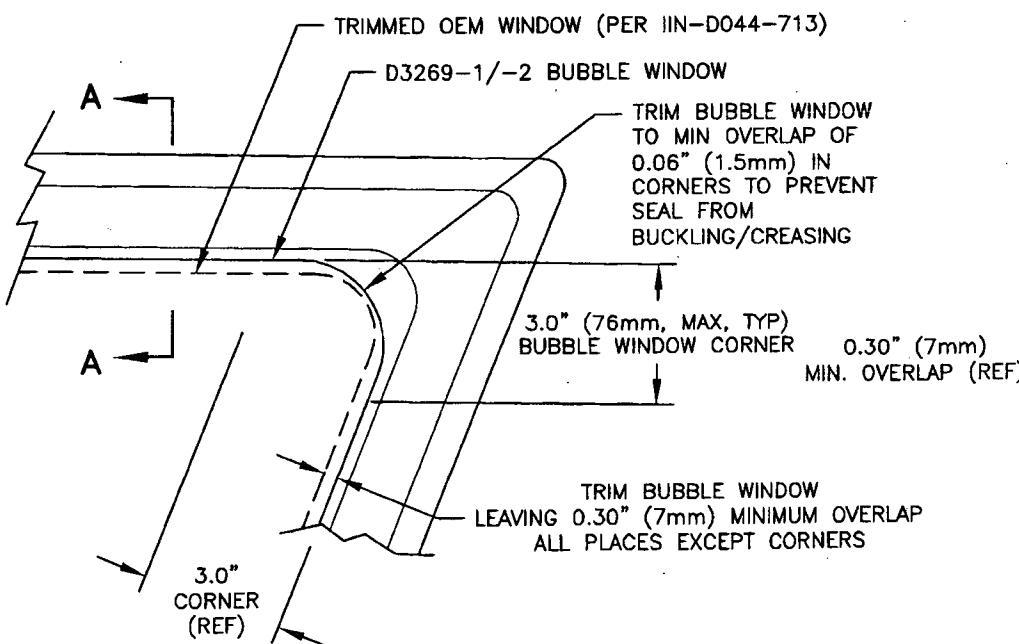
**PURPOSE:** For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

**PROCEDURE:**

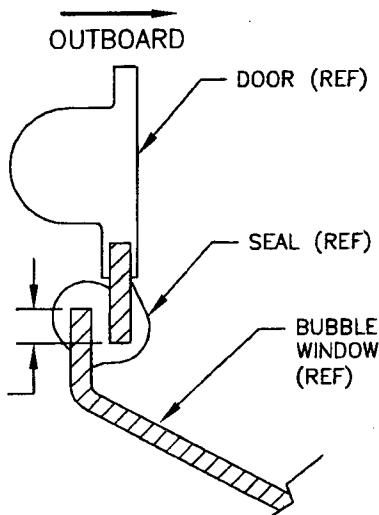
- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

**FIGURE 1**

LOOKING AT INSIDE CORNER OF DOOR

**SECTION A-A**

(NOT TO SCALE)



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.06.26
CERT. NO.:	SH05-13
ISSUE NO.:	1

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